



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

SWA6A-2
Job Sheet 173793



Part No: SWA6A-2

Job Qty: 1 ea

Part Name: Electric Swivel 6,000 lb Safe Work Load (2,721 Kg)



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 3/7/18

Job Tracking No:

Due Date: 3/23/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG SWA6A-2 Rev4 IPP Rev A 17.11.15 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		3/22/18	0.00	0.00	Start Up Small Fab-2		
110	Small Fab	1 pcs		3/23/18	0.00	2.00	Small Fab-6		AP DAS
120	QC	1 pcs		3/23/18	0.00	0.00	QC5		38
125	DC	1 pcs		3/23/18	0.00	0.00	DC		9-89
130	Packaging	1 pcs		3/23/18	0.00	0.00	Packaging3		DAS
140	QC21-FG	1 Ea		3/23/18	0.00	0.00	QC21		21 MAR 15 2018

Part Op 110 - Assemble as per DWG. Sheet 1 ***All assembly to be done in accordance with SWA swivel manual*** Engrave T/N
Descriptions: And / or S/N number as required Using Marktronic engraver as per DWG. Laser engrave dart logo as per DWG.

120 - Engrave T/N And / or S/N number as required Using Marktronic engraver as per DWG.

125 - Photocopy blue file OM & OOPM-SWA6A Rev2

130 - Bag and tag

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
SWA6A-800A	Connector Bushing	1 Ea (1 ea)	90-Start up Operation	5026924
188-FPSS-1032-5/8	Set Screw	1 Ea (1 ea)	110-Small Fab	5037093
188-FSCS-1032-5/8	Wire Clamp Screw	4 Ea (4 ea)	110-Small Fab	5027240
C45-15-13	Sleeve	1 pcs (1 ea)	110-Small Fab	5029310
EL-PLUG-F	3-Prong Female Spade Plug	1 Ea (1 ea)	110-Small Fab	5027230
EL-PLUG-M	3-Prong Male Spade Plug	1 Ea (1 ea)	110-Small Fab	5027231
EL314-SJTOW	3 Wire	6 ft (6 ea)	110-Small Fab	5029542 5047767
N13000 300 SPP	Circlip Internal	1 (1 ea)	110-Small Fab	
SWA6A-100	Lower End	1 Ea (1 ea)	110-Small Fab	5032354
SWA6A-1100	Upper Bearing	1 Ea (1 ea)	110-Small Fab	5040726
SWA6A-1200	Lower DU Bearing	1 Ea (1 ea)	110-Small Fab	5044605
SWA6A-1300	Lower Thrust Bearing	1 Ea (1 ea)	110-Small Fab	5040328
SWA6A-1400	Circlip Internal	1 Ea (1 ea)	110-Small Fab	5045017
SWA6A-1800	Cover	1 Ea (1 ea)	110-Small Fab	5040978
SWA6A-1900	Female Spade Terminal - 1/4"	4 Ea (4 ea)	110-Small Fab	5047603-5027243
SWA6A-200	Upper End	1 Ea (1 ea)	110-Small Fab	5032403
SWA6A-300	Bearing Housing	1 Ea (1 ea)	110-Small Fab	5040760
SWA6A-400	Thrust Washer	1 Ea (1 ea)	110-Small Fab	5035446
SWA6A-500	Semi Rings	1 Ea (1 ea)	110-Small Fab	5035127
SWA6A-600	Collar	1 Ea (1 ea)	110-Small Fab	5034731
SWA6A-700	Wire Clamp	2 Ea (2 ea)	110-Small Fab	5029417

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QS1042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____			
Misidentified ☐	Past Due ☐				

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	SWA6A-800A	1	34	0
110-Small Fab	188-FPSS-1032-5/8	1	396	0
	188-FSCS-1032-5/8	4	176	0
	C45-15-13	1	0	0
	EL-PLUG-F	1	38	0
	EL-PLUG-M	1	35	0
	EL314-SJTOW	6	1,181	0
	N13000 300 SPP	1	0	0
	SWA6A-100	1	10	0
	SWA6A-1100	1	9	0
	SWA6A-1200	1	39	0
	SWA6A-1300	1	19	0
	SWA6A-1400	1	9	0
	SWA6A-1800	1	10	0
	SWA6A-1900	4	64	0
	SWA6A-200	1	8	0
	SWA6A-300	1	9	0
	SWA6A-400	1	9	0
	SWA6A-500	1	9	0
	SWA6A-600	1	9	0
	SWA6A-700	2	32	0
	SWA6A-900A	1	0	0

Part Specifications



Container No: S048769



Part: SWA6A-2

Job No: 173793

Serial No/Batch: S048769

Revision: 4

Inspector:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

! Dart.lajeunesse.marie

Date: 03/07/18

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Date :		Step #:		QTY Effective :			MRB (QS1042) Approval																		
Description Work Order Deviation				Disposition				Completed By																	
Root Cause				FAULT CATEGORY																					
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐		No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐		Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐		Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐		Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐															
OTHER : _____																									

Work Order 173793

Customer _____

Number of Wires 2Date 13 March 2018Serial Number 5048769

Number of Cycles	Load (Lbs.)	Action	Pass/Fail
1	6,000	Check for Conductivity against all wires.	- Pass
1	6,000	Check all wires for grounding against swivel body.	- Pass
1	3,000	Check for Conductivity against all wires.	- Pass
1	3,000	Check all wires for grounding against swivel body.	- Pass
1	1,500	Check for Conductivity against all wires.	- Pass
1	1,500	Check all wires for grounding against swivel body.	- Pass
1	0	Check for Conductivity against all wires.	- Pass
1	0	Check all wires for grounding against swivel body.	- Pass

Test Conducted By:

Mathieu Hecart

Technician

Signature: _____

Director of Quality Assurance

DAS
55
9-89**Submit**